

### Abstract

[0057] A system and process for gas assisted plastic injection molding. The plastic material is injected into the mold cavity and the molding pressure is held for a period of time. Thereafter, gas is injected into the plastic material and the pressure is again held for a period of time. Thereafter, valve members are opened allowing plastic to be expelled into one or more secondary cavities, or to be expelled back into the machine barrel.

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